

Work Order ID 131927

Tuesday, April 21, 2015 1:57:01 PM

131927

Page 1

Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Crosstube Installation with Step (no hardware)
 Start Date: 4/20/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								
120	Pick Kit	0.00							DAS
120	Packaging					1			41
Packaging	Memo	0.00							9-89
Packaging									15-5-21
130	Crosstubes	0.00							DAS
130						1			41
Crosstubes	Memo	0.00							15-5-21
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-251								
	Torque all clamps to 50 IN-LBS max.								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						1			2B
QC	Memo	0.00							15-05-21
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Start Date: 4/20/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-251								
				USED ON					
				W/O B132854					
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ MAY 21 2015

MS-5.21

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Work Order ID: 131927

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Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1		DAS 41 9-89	
D119-796-241					131552				**	1		15-5-21	
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	24.0000		4			
D5123-3									**				
Clamp Cushion													
					131871					4			EN 15-05-19
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					Ig55			24					
					126747			16					
					127133			6					
					131009			2					
D5149-043		Manufactured	No				Each	0.0000		2			
D5149-043					131333				**	2			CH 15-05-19
Aft Step Base Assembly													
MS21920-25		Purchased	No				Each	56.0000		4			
MS21920-25									**				
Clamp													
										2+1		DAS 41 9-89	15-5-21
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG			10					
					120920			10					
					LG050			46					
					M130400			10					
					M131367			3					
					M131856			33		1			

DQA: _____ Date: _____



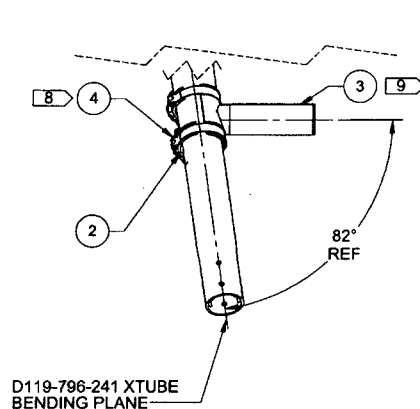
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

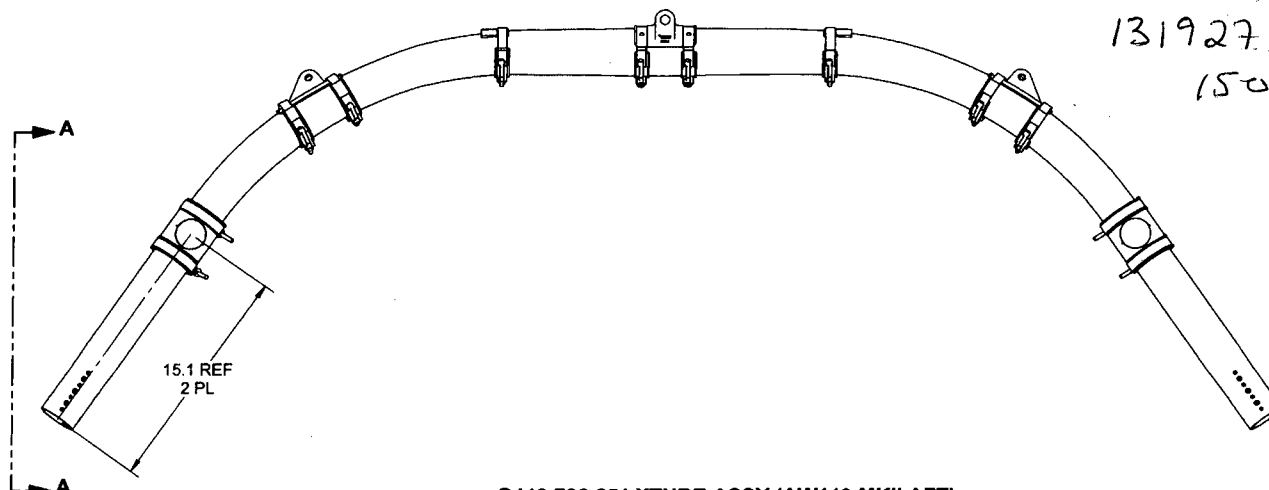
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ITEM	QTY -251	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D119-796-251	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED